

Date: Monday, 2/27/2006 4:22:24 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer :</b>	CU-DAR001 Dart Helicopters Services	<b>Drawing Name :</b>	LUG BRACKET
<b>Job Number :</b>	26003		
<b>Estimate Number :</b>	10009		
<b>P.O. Number :</b>	N/A	<b>Part Number :</b>	D27351
<b>This Issue :</b>	2/27/2006	<b>S.O. No. :</b>	N/A
<b>Prsht Rev. :</b>	NC	<b>Drawing Number :</b>	D2735 REV C
<b>First Issue :</b>	N/A	<b>Project Number :</b>	N/A
<b>Previous Run :</b>	24899	<b>Drawing Revision :</b>	C
	<b>Type :</b>	<b>Material :</b>	N/A
	PURCHASED PARTS	<b>Due Date :</b>	3/15/2006
<b>Written By :</b>	<i>See comment below</i>		<b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By :</b>	<i>06.02.28</i>		
<b>Comment :</b>	Est Rev:C Removed from 9 Digit 05-10-25 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 00000685

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per Dwg D2735

Possible supplier: Ind. Laser

Material release note is required.

2.0	D27351F	Lug Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Lug Bracket

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions per templates D2735-1T1 &amp; DWG D2735

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

2-Deburr if required.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 22 Date: 06/05/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/27/2006 4:22:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 26003

Part Number: D27351

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*26.01.22*

*41*

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS7*

*CPL 06.05.03*

*(41)*

8.0

DC

DOCUMENT CONTROL



*(41)*

Comment: DOCUMENT CONTROL

Inspection Level 21

*DP 06/05/04*

Job Completion



*u dec 08.04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

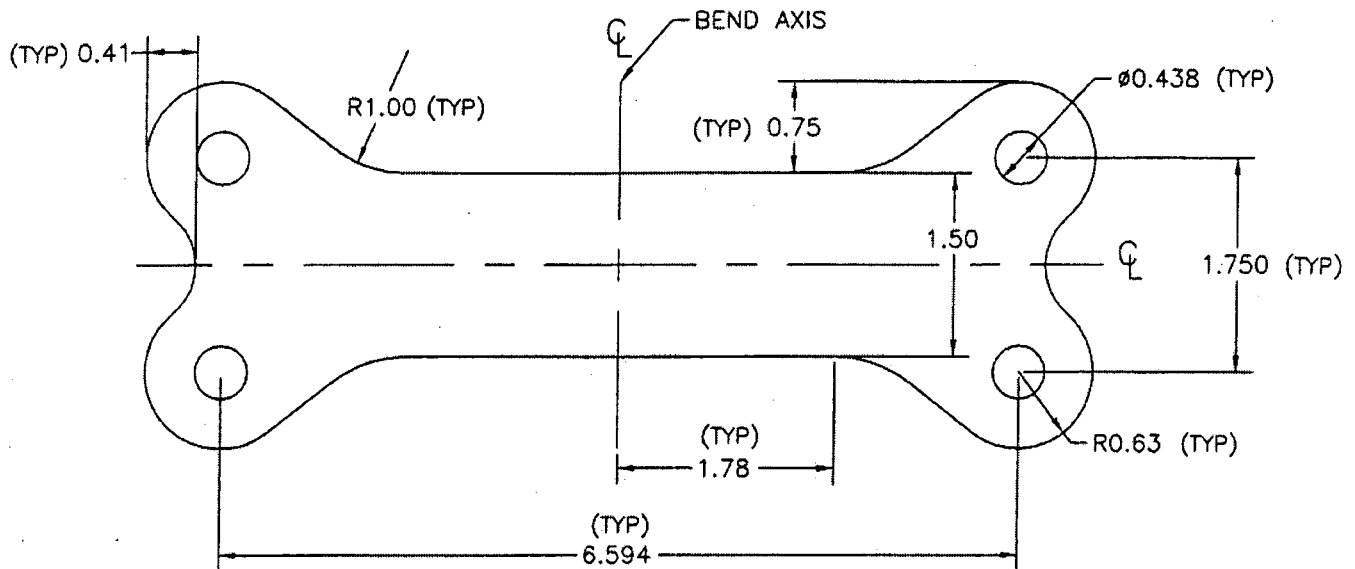
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

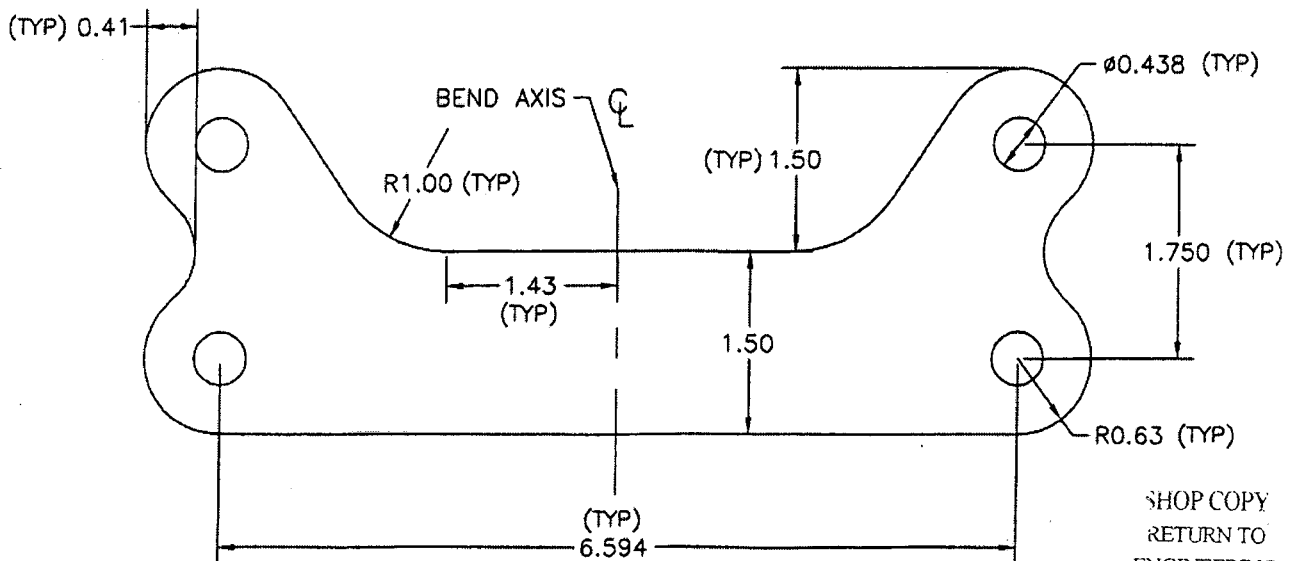


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED  
98.12.14 DS

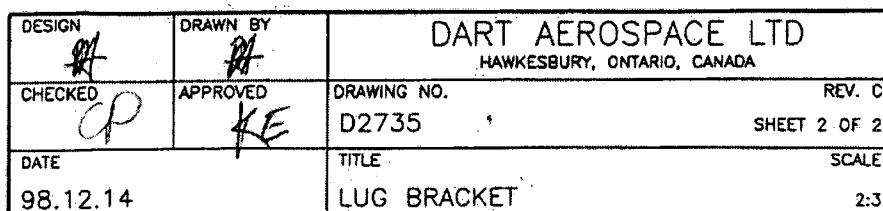


D2735-1 FLAT PATTERN  
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)

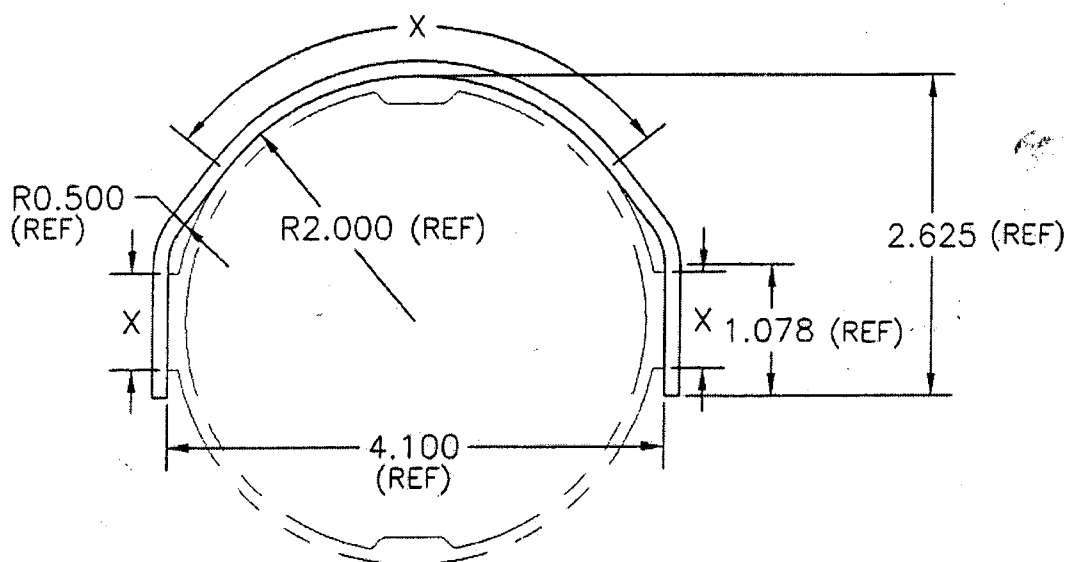


D2735-3 FLAT PATTERN  
SYMMETRIC ABOUT CENTRE-LINE (CL)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER



RELEASED  
98.12.14 DS



D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.125 THICK (11 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY

SUBJECT TO AMENDMENT  
WITHOUT NOTICE

## WORK ORDER.

NO. 26002



New Zealand Steel Limited  
Glenbrook, South Auckland  
Postal: Private Bag 92121, Auckland, New Zealand  
Telephone: (09) 375 9989 / 375 8111 Auckland  
(09) 235 8089 / 235 3535 Waikato  
Fax: (09) 375 9999

# TEST CERTIFICATE

Ref: 5748/25194

Reissued 1/12/2005

CUSTOMER		Wilkison		P50916R1001														SPECIFICATION		ASTMA1008 CS Type A				CERTIFICATE No		TC122435	
CUSTOMER O/N		90-21N-963																PRODUCT		CRA WIDE COIL				PAGE		1 of 1	
MILL O/N		597683																DIMENSIONS		0.114" x 48" x Coil				DATE		29 November 2005	
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT																MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)									
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ( )	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH			
		x100			x1000										x10000		x100		180°				G.L.=	HRB	( )	(feet)	
R9-471775-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				51		794			
R9-471776-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				51		682			
R9-471777-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				54		768			
R9-471778-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				54		690			

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS		GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 So (F)=8"		PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r45 (B)=r90 (D)=(r0+r90+2r45)/4		IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm		CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=	
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*  
QC METALLURGIST

60207KA012-2 T M INDUSTRIAL (P50916D1001) (09)